

Quick Silver

Work Order ID 51857



Tuesday, September 08, 2009 8:40:36 AM

Item ID: D206-628-014QS

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Step RH-QUICK SILVER

Start Date: 9/4/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 9/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: *[Signature]* Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
N/A	Rev N/A								

150

0.00



SprayPaint

Memo

0.00

Spray Painting

PULL FROM STOCK

1 X D206-628-014 B 36964 CHG 004

REMOVE FROM KIT ALL LUGS, D2731-3 / -7, D3394-041/-043, and arm D2845

SCUFF STEP AND ALL PARTS ABOVE TO RE-PAINT IMRON QUICK SILVER B 112614

APPLY IMRON CLEAR B 112632

MM 09 09 09

160

QC14- Inspect Spray Paint

0.00



QC

Memo

0.00

Quality Control

RT 09 09 10

DART Dart Aerospace Ltd. 120 ABERDEEN ST HAWESBURG ON, CANADA K6A 1K7			
TC APPROVAL # 09-89		TEL: 1-613-632-5200	
P.T.	D206-628-014	CHG	CHG004
DESC	Heli-Access-Step RH	STC	SH98-14
LUT	B36964	STC	SA00500SE
MODEL	Bell 206A/B	STC	
MADE IN CANADA D2729-1			

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

170

0.00



HandFinish

Memo

0.00

Hand Finishing

RE-WINGWALK
B 11/2/06

BR 09-09-10

①

180

0.00



QC

QC3- Inspect Part Finish

Memo

0.00

Quality Control

JL 09/09/11

1 9

190

0.00



Packaging

Memo

0.00

Packaging

RETURN LUGS D2731-3 / -7, D3394-041/-043 AND ARM D2845 TO
ORIGINAL KIT

REV F

9/9/14 ① 50

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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200

0.00



QC

Memo

0.00

Quality Control

27 809/09/14

4124

210

0.00



Packaging

Memo

0.00

Packaging

RE-PACKAGE PER PPP USING NEW B/N
NEW LABELS REQ'D

809/09/14

9/9/14 QSP

220

0.00



QC

Memo

0.00

Quality Control

QC21- Final Inspection - Work Order Release

09/09/14

mf 09-09-14

Picklist Print

Page 1

Tuesday, September 08, 2009 8:40:35 AM

Work Order ID: 51857



Parent Item: D206-628-014QS



Parent Item Name: Heli-Access-Step RH-QUICK SILVER

Start Date: 9/4/2009

Required Date: 9/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D206-628-014RevN/A		Manufactured	No				Each	7.0000	1.0000			

Heli-Access-Step RH

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FG

2

18943

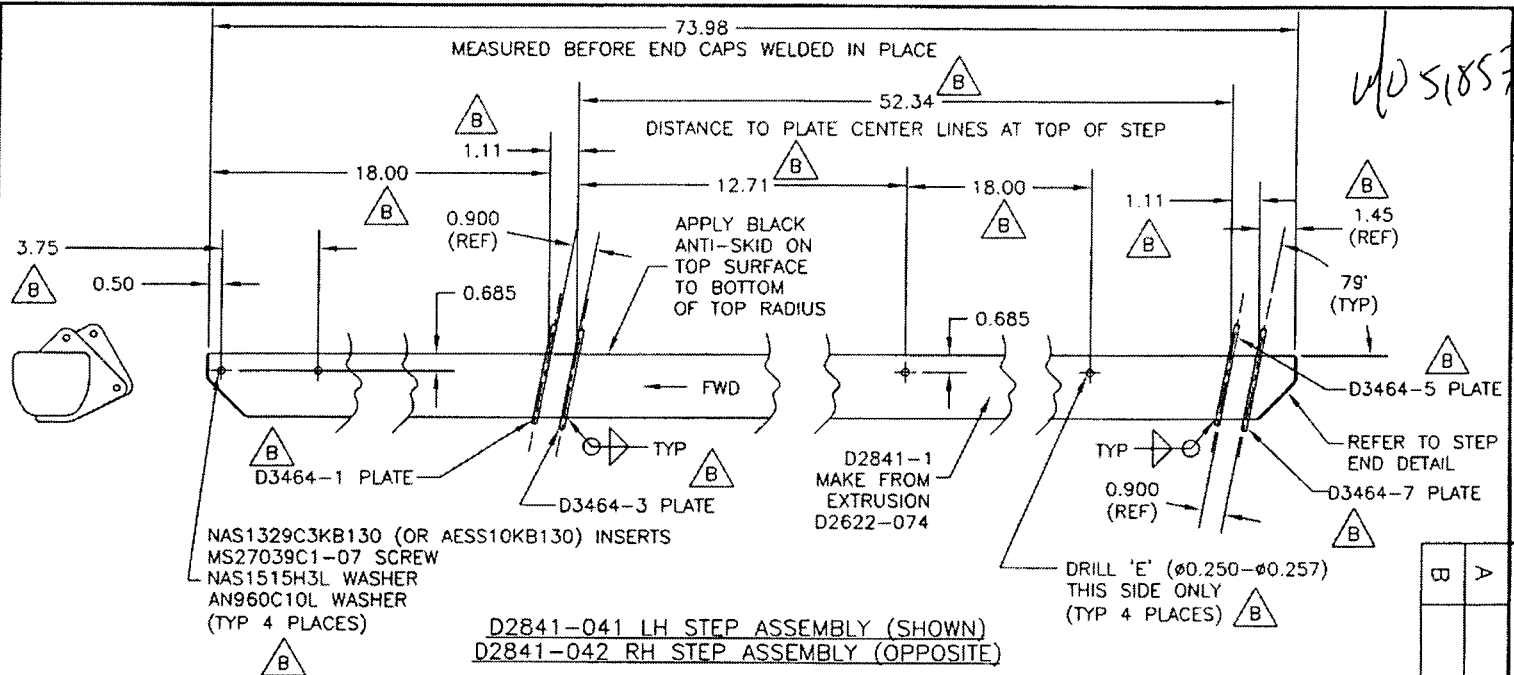
2

36964

5

mp/ 2 09 09

DART



D2841-041 LH STEP ASSEMBLY (SHOWN)
D2841-042 RH STEP ASSEMBLY (OPPOSITE)

D2841-041/-042 STEP ASSEMBLY PARTS LIST

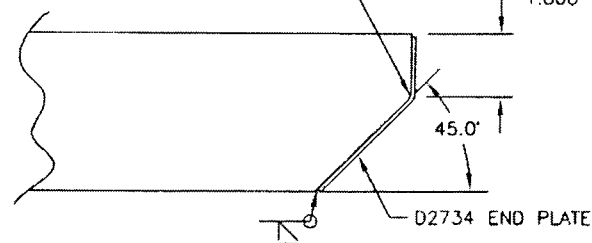
QTY	QTY	PART NUMBER	DESCRIPTION
041	042		
X	X	D2841-041	LH STEP ASSEMBLY
X	X	D2841-042	RH STEP ASSEMBLY
1	1	D2622-074	EXTRUSION
1	1	D3464-1	PLATE
1	1	D3464-3	PLATE
1	1	D3464-5	PLATE
1	1	D3464-7	PLATE
2	2	D2734	END PLATE
4	4	NAS1329C3KB130 (OR AESS10KB130)	INSERT
4	4	MS27039C1-07	SCREW
4	4	NAS1515H3L	WASHER
4	4	AN960C10L	WASHER

NOTE: ALL WELDS SHALL
BE 100% VISUALLY
INSPECTED BY A QUALIFIED
INSPECTOR PER DART
QSI 004

D2841-041/-042 STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

ROUND CORNER OF EXTRUSION TO
MATCH BEND RADIUS OF END PLATE



TYPICAL STEP END DETAIL
NOT TO SCALE

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
KE	PH	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
PH	PH	D2841
DATE	TITLE	REV. B
05.09.21	206B FLOAT STEP ASSEMBLY	SHEET 1 OF 1
A	98.10.14	SCALE
B	05.09.21	NTS
	RE-DESIGN, ADD D2843-1/-3/-5/-7	

RELEASED
05/11/4

Date: Monday, 04/02/2008 3:21:08 PM
 User: Dominique Dube

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 206 A/B FLOAT STEP ASSEMBLY
Job Number : 36964	
Estimate Number : 11792	
P.O. Number :	Part Number : D206628014
This Issue : 04/02/2008 S.O. No. :	Drawing Number : N/A
Prsht Rev. : NC	Project Number : N/A
First Issue : 25/01/2008 Type : LARGE FAB ASSY	Drawing Revision : N/A
Previous Run :	Material :
Written By : <u>[Signature]</u>	Due Date : 10/03/2008 Qty: 6 Um: Each
Checked & Approved By : <u>[Signature]</u>	
Comment : Est Rev:D As Per Ecn 766 06-01-06 JLM	

Additional Product

REFERENCE ONLY

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy blue file and type labels as per PPP D206-628-014 CHG 002 004 per Ecn 1118

2.0	36964A	206B FLOAT STEP ASSY, RH
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Comment: Sub-Component SUB-ASSEMBLY

206B STEP ASSY, RH
D2841-042 B 36964A

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

UPDATED AS PER Ecn 1118, D206-628-014 CHG NUM. 004

4.0	D27313	Mounting Lug
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2731-3 Mounting Lug 37335

5.0	D27317	Mounting Lug
-----	--------	--------------



Comment: Qty.: 2.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2731-7 Mounting Lug B34125

Date: Monday, 04/02/2008 3:21:08 PM
User: Dominique Dube

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 A/B FLOAT STEP ASSEMBLY

Job Number: 36964

Part Number: D206628014

Job Number:



REFERENCE ONLY

Seq. #:

Machine Or Operation:

Description :

6.0

D2845

Arm

S



Comment: Qty.: 2.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2845 ARM B36089 x1 B37339 x9 B18968 x2

AS 08/04/03 (x6)

7.0

D2732030

Rubber Cushion



Comment: Qty.: 4.0000 Each(s)/Unit Total: 24.0000 Each(s)

Pick:

Qty Part # Description Batch

4 D2732-030 RUBBER CUSHION

ERROR

8.0

D2732030

Rubber Cushion

S



Comment: Qty.: 4.0000 Each(s)/Unit Total: 24.0000 Each(s)

Pick:

Qty Part # Description Batch

4 D2732-030 RUBBER CUSHION

ERROR

Total = 48

AS 08/04/03 (x6)

9.0

D3394041

LUG ASS'Y

S



Comment: Qty.: 2.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3394-041 LUG ASS'Y 31833

AS 08/04/03 (x6)

10.0

D3394043

LUG ASS'Y

S



Comment: Qty.: 2.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3394-043 LUG ASS'Y B34834

AS 08/04/03 (x6)

11.0

AN3C4A

BOLT

6



Comment: Qty.: 2.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 AN3C4A Bolt M107376

AS 08/04/03 (x6)

Date: Monday, 04/02/2008 3:21:08 PM
User: Dominique Dube

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 A/B FLOAT STEP ASSEMBLY

Job Number: 36964

Part Number: D206628014

Job Number:



Seq. #: Machine Or Operation: Description : **REFERENCE ONLY**

12.0 AN4C13A BOLT

S



Comment: Qty.: 4.0000 Each(s)/Unit Total: 24.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 AN4C13A

Bolt

M105089 x 10 M106785 x 14

AS 08/04/03 (X6)

13.0 AN4C14A Bolt

S



Comment: Qty.: 4.0000 Each(s)/Unit Total: 24.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 AN4C14A

Bolt

M107087

AS 08/04/03 (X6)

14.0 AN4C15A Bolt

S



Comment: Qty.: 4.0000 Each(s)/Unit Total: 24.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 AN4C15A

Bolt

M103915

AS 08/04/03 (X6)

15.0 AN960C10 WASHER

C



Comment: Qty.: 2.0000 EACH(s)/Unit Total: 12.0000 EACH(s)

Pick:

Qty Part Number

Description

Batch

4 AN960C10

Washer

M106302

AS 08/04/03 (X6)

16.0 AN960JD416L Washer

S



Comment: Qty.: 24.0000 Each(s)/Unit Total: 144.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

24 AN960JD416L Washer

M106785 x 78 M10708 x 66

AS 08/04/03 (X6)

17.0 NAS1515H4L WASHER

S



Comment: Qty.: 24.0000 Each(s)/Unit Total: 144.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

24 NAS1515H4L Washer

M107008

AS 08/04/03 (X6)

Date: Friday, 1/25/2008 10:49:23 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 A/B FLOAT STEP ASSEMBLY

Job Number: 36964

Part Number: D206628014

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

MS210434

Nut

REFERENCE ONLY

S



Comment: Qty.: 12.0000 Each(s)/Unit Total : 72.0000 Each(s)

Pick:

Qty Part Number Description Batch

12 MS21043-4 Nut (or MS21042-4) M107101

AS

08/04/03

(x6)

19.0

NAS1515H3

Washer

S



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 NAS1515H3 Washer

M107101

AS

08/04/03

(x6)

20.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

08/04/07

(x6RH)

21.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-628-014

Location:

30964A

PPP Rev:

Rev F

AS

08/04/07

(x6)

22.0

QC21

FINAL INSPECTION/W/O RELEASE



08/04/09

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 08-04-08

W